

Date: Tuesday, 10/17/2006 11:21:31 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GAS SPRING ASSEMBLY
Job Number : 29047	
Estimate Number : 10181	
P.O. Number : <i>N/A</i>	Part Number : D2153
This Issue : 10/17/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2153 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED/PARTS	Drawing Revision : A1
Previous Run : 26155	Material : <i>N/A</i>
Written By : _____	Due Date : 10/30/2006
Checked & Approved By : <i>[Signature]</i>	Qty: <i>108</i> Um: <i>12</i> Each
Comment : Est: E 02.07.08 Re-format KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *2261*

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation *attwood*

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

C206110117 (108)

2.0	D2153P	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 GAS SPRING ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

206110117 108

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

206-10-24 108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Lock Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Lock Nut

214

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

328706

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

216

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

M101369 79

M102328 137

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

M102458 120

M10036986

06/10/25 (108)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

06/10/25 (108)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-10-25 (108)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST218

06/10/26 (108)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *RP* Date: *6/15/28*
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29047

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



108

Comment: FINAL INSPECTION/W/O RELEASE

19 06/10/26

Job Completion



u 06.10.26

Dart Aerospace Ltd

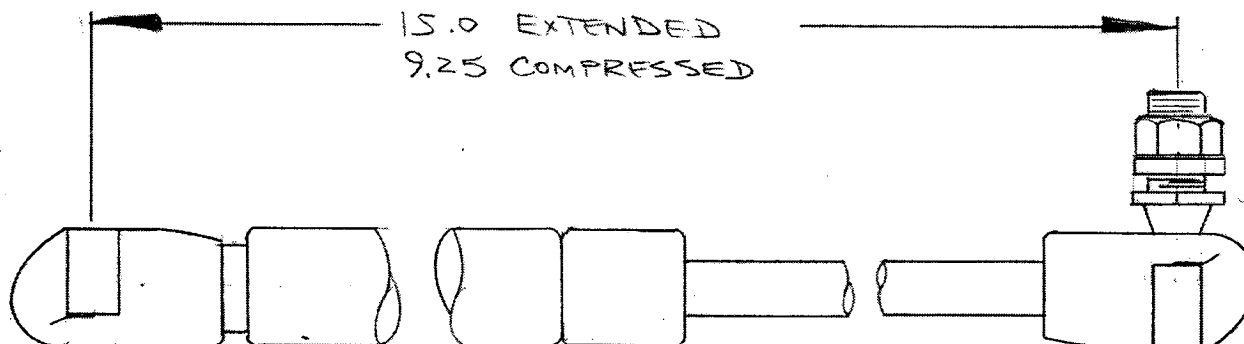
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SL-18-10 SPRING (SPRING LIFT CORP)

SL69-BS STUD (SPRING LIFT CORP)

AN 960-516 WASHER

5/16-18 UNC SELF LOCKING NUT
D3015-3 Δ 1



RELEASED
96/07/16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 29047
WORK ORDER

REVISION DRAWN APPROVED		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC/VENDOR					
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 7242 5. HOLES PER AND 10087		LIMITS 1. TOLERANCES — .005 & .030 2. ANGLES 1/2" & 1/16" 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MTC CENTRE LINES .005		BASIC CODE DIL DASH NO. W-HEAD NEAR SIDE W-HEAD FAR SIDE D-COMPILE DIGIT-NO OF SHEETS C-COUNTERSINK BASIC CODES 8H-15204 1040 8B-145 204 2640		CONTRACT NO. HATTON 27.28.22		DATE 27.28.22		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		TITLE GAS SPRING ASSEMBLY		CODE DOW NO DZ153		REV. A	
01.05.01 CHANGE TO D3015-3 SL 18-10 51-3875 1447		REPORT ALL DISCREPANCIES — DO NOT SCALE		CLIENT HATTON 27.28.22		SCALE 1:1		SHEET 1 OF 1		96/07/16		2153		2153					

attwood**SWIVLEZE**

TELEPHONE: 512-897-2290

CUST: 68580 MST: 36442-00

~~CCH~~

PP/A

BILL TO: DART AERO LTD.
REQ: 10/18/06PRO NO: 442 99800
SHIP VIA: UPS GROUND
BOL: 002269700000312457

FREIGHT: _____

F ATTWOOD / SWIVLEZE

R

O 1016 NORTH MONROE

M LOWELL

MI 49331-0260

T DART AERO LTD,
O 1270 ABERDEEN STREET

HANKSBURY

ON

K6A 1K7

CPTS:

1 X

PO#: 2261

NOT:

42

DATE: 10/18/06

SFUR: 8

LABEL NO:
40926600C

---ROUTING GUIDE INFO---

---SHIPPED---

CPTS	QTY	LOCATN	UN	PART#	UPC	DESCRIPTION / SKU	LINE	QTY	ORDER
3	108 ✓	Z09211	EA	SL13-10-1	✓	SS SPRNG 15" EXTC 10# BL	1	108	
2	200	Z10321	EA	SL69-B5-1		10MM BALL STUD N/THRD	2	200	



===== COMPLETE =====

PICK BY: _____

PAGE: 1 (ONLY PAGE)